

Date: Thursday, 02/04/2009 9:13:23 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642-512
Job Number : 46796	
Estimate Number : 10804	
P.O. Number :	Part Number : D206642512
This Issue : 02/04/2009 S.O. No. :	Drawing Number : REWORK
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SKIDTUBES	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 02/04/2009 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISHING1	HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

PULL FROM STOCK:

- 1 X D206-642-512 B 44512 CHG003

REMOVE ALL WEARPLATES, GASKETS AND END CAP
DISCARD SCREWS, WASHERS AND GASKETS
(KEEP WEARPLATES TO RE-ASSEMBLE)

PRESSURE WASH INSIDE AND OUTSIDE OF
TUBE TO REMOVE ANY LPS3

DART		TEL.: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-512	CHG	CHG003
DESC	Float Skidtube RH	STC	SH98-4
LOT	B44512	STC	SA00475SE
MODEL	206L/L1/L3/L4/407	STC	
US PATENT # 5735483 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

HL 09-04-02 (X1)

2.0	D206642512	Float Skidtube RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Float Skidtube RH

HL 09-04-02 (X1)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/02 (X1)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

REASSEMBLE PER DRWG D3274 REV.D

NEW SCREWS, WASHERS AND GASKETS REQUIRED:

HL 09-04-02 (X1)

Date: Thursday, 02/04/2009 9:13:23 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46796

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 78 X AN3C4A B 111279
✓ 78 X AN960C10L B 111193
✓ 1 X D3536-15 B 40287
✓ 1 X D3536-23 B 33965
✓ 1 X D3536-35 B 38905
✓ 1 X D3536-39 B 33966

USE EXISTING WEARPLATES AND

Replace
CAP ⇒ D2646/1346327

✓ DO NOT SPRAY WITH LPS!!

HL 09-04-02 (K)

5.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)
BOLT B 111279 HL

6.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)
washer B 111193 HL

7.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket B 40287 HL

8.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket B 33965 HL

9.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket B 38905 HL

10.0

D353639

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Gasket B 33966 HL 09-04-02 (K)

Date: Thursday, 02/04/2009 9:13:23 AM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46796

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/9/02 @

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Rev D

(14)

RE-PACKAGE USING NEW B/N

NEW LABELS REQUIRED

CH 4003

16642-512 B 433 73 Gte

ENSURE ORIGINAL KIT PACKAGED WITH SKIDTUBE

9/4/2

SP

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/02

Job Completion



U 09.04.02

DART

RELEASED

07.02.12

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

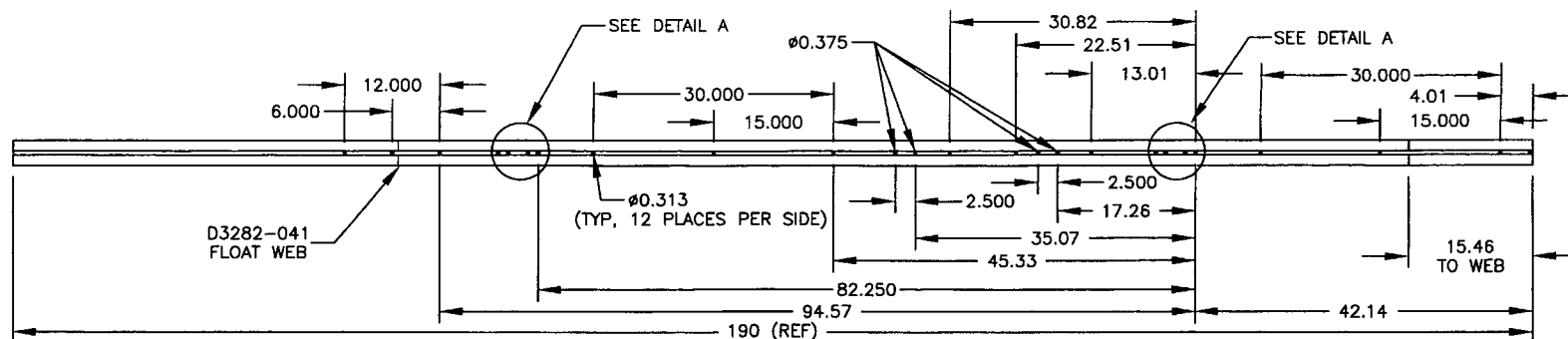
Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

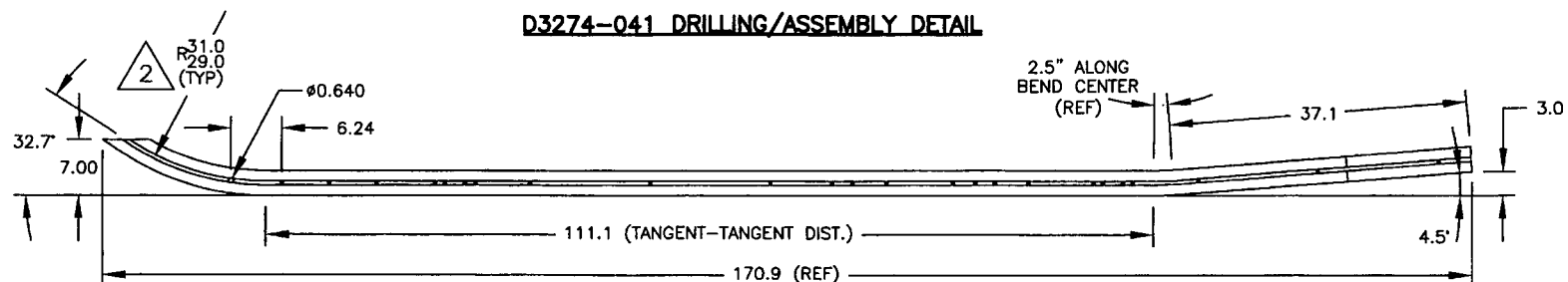
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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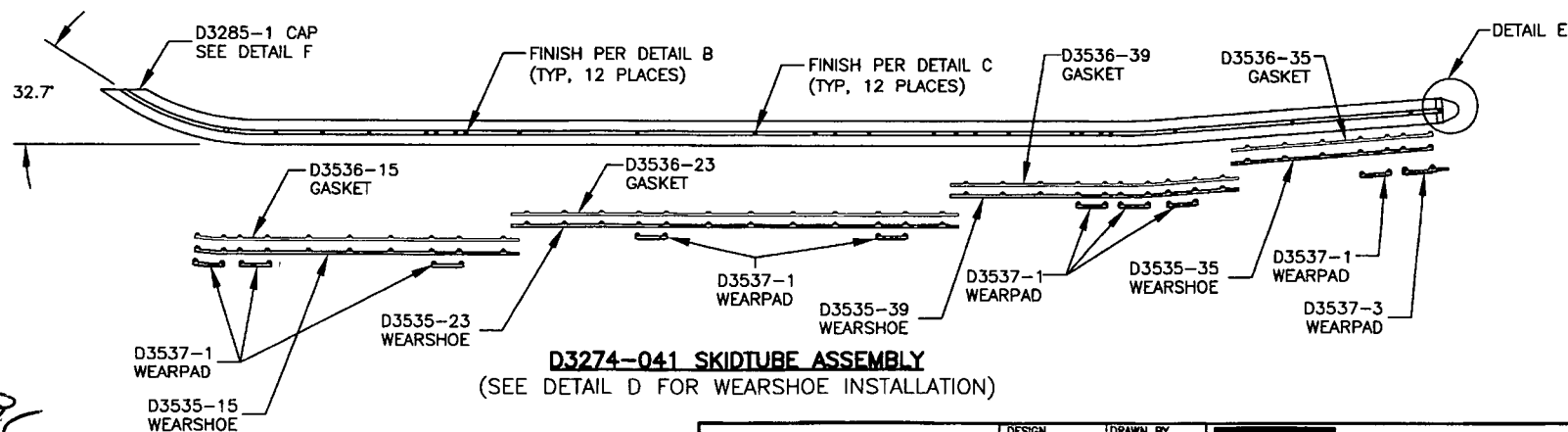
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

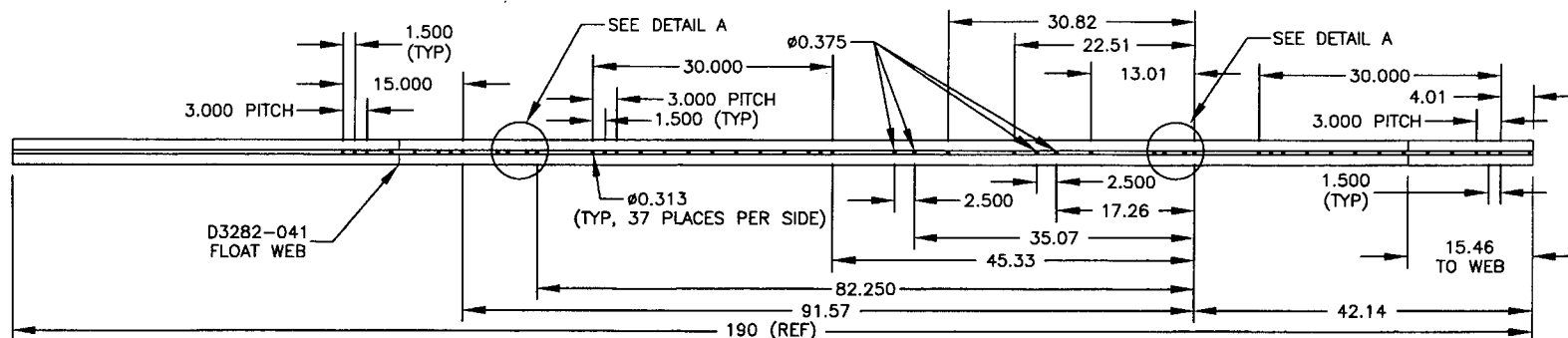
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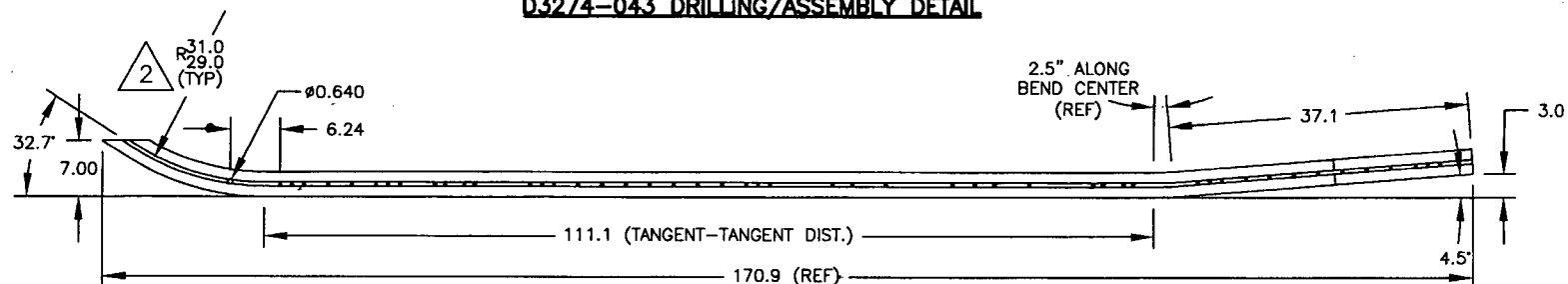
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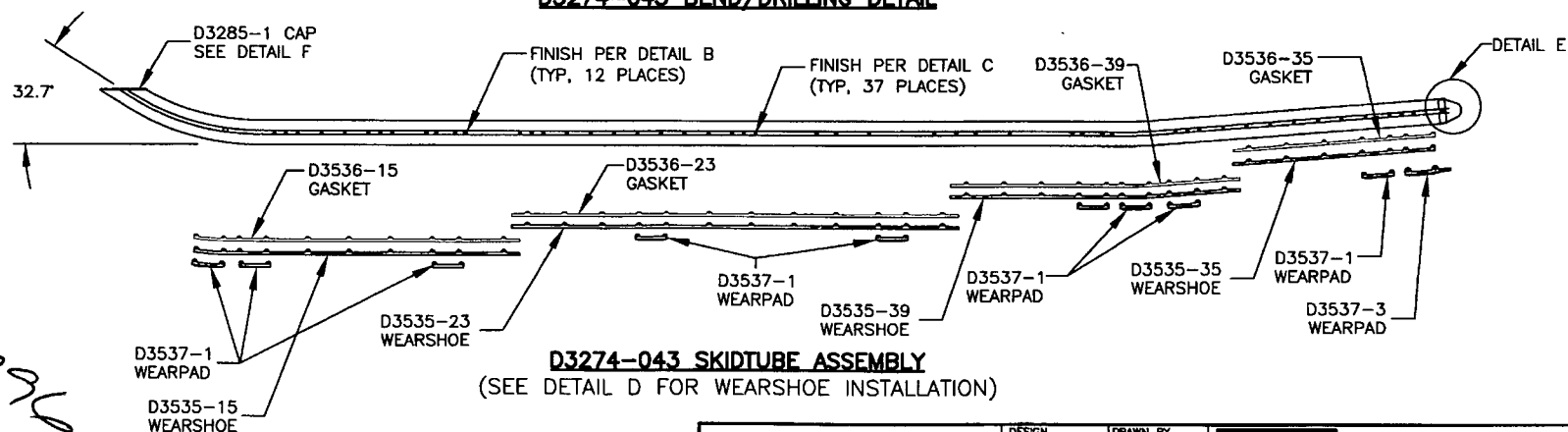
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CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



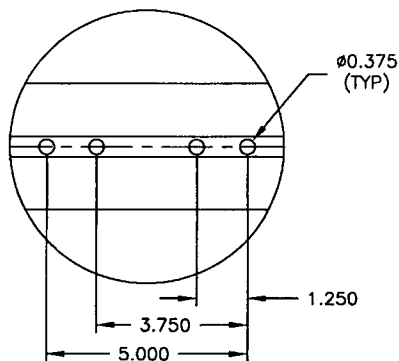
D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

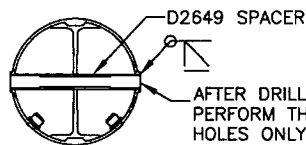
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DATE	06.12.19	TITLE	D3274		SHEET 3 OF 4
			SKIDTUBE ASSEMBLY		SCALE 1:15

DETAIL A: DRILL DETAIL

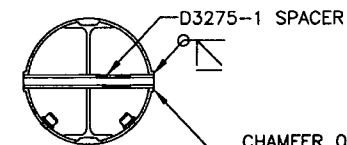


DETAIL B FOR 0.375 HOLES ONLY



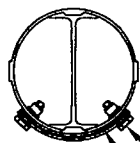
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



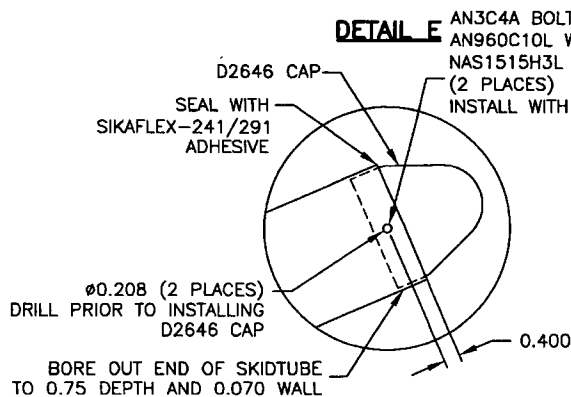
CHAMFER 0.030x45°
(TYP)

DETAIL D

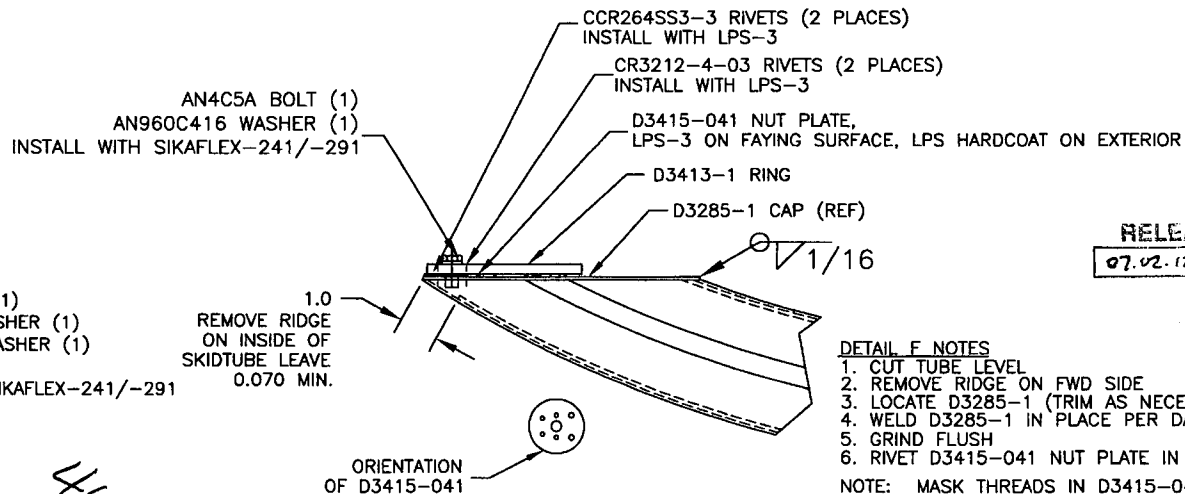


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
07.02.12

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		DATE	06.12.19	TITLE		SKIDTUBE ASSEMBLY	SCALE 1:3